

Work Order ID 78307

January-05-12 8:30:42 AM

Ship March 25/19
Accept

78307

Page 1.

Item ID: D2282-043
Revision ID:
Item Name: Saddle Assembly
Start Date: 05/01/2012 Start Qty: 50.00
Required Date: 23/03/2012 Req'd Qty: 50.00
Reference:

50
50

N9000040100

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: Process Plan: M.L.J Date: 12/01/05 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2282	Rev E

100		0.00
-----	--	------

100 Large Fab

Large Fab

Large Fab

Memo

0.00

I-Weld as per D2282-043 Saddle Assembly
A/RER316L SS Filling Rod M115778
Dwg Rev: E

12-02-21 50x

110		0.00
-----	--	------

110 Small Fab

Small Fab

Small Fab

Memo

0.00

I- Grind weld with rough pad and brown pad, take all welding marks out and deburr holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***

12/02/02

(x50)

120	QC9- Inspect visual per QS1004- Fusion Welds	0.00
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120

QC

Quality Control

Memo

0.00

12-02-24

50x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78307

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Item ID: D2282-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle Assembly
 Start Date: 05/01/2012 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 23/03/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Memo 1 -Tumble	0.00 0.00				<i>NA</i>	<i>12</i>	<i>03</i>	<i>15</i> (50)
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	<i>SP</i>	<i>12/03/19</i>		(50)			
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <i>GA</i> Memo	0.00 0.00				<i>SP</i>	<i>12/03/19</i>	(50)	

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Saddle Assembly

Start Date: 05/01/2012 **Start Qty:** 50.00

50

Cust Item ID:

Required Date: 23/03/2012 **Req'd Qty:** 50.00

50

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ 12/03/19

MF
12-03-19

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NOTE: Date & initial all entries

Picklist Print

January-05-12 8:30:46 AM

Page 1

Work Order ID: 78307

78307

Parent Item: D2282-043

D2282-043

Parent Item Name: Saddle Assembly

Start Date: 05/01/2012

Required Date: 23/03/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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✓ D2281		Manufactured	No			100	Each	73.0000	1	50			
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D2281

Jack Saddle

**

B78311 → 4x

Location

Loc Qty

Loc Code

WA020

73

67539

67

74885

6

SY 12.02.19

6x

✓ D2282-7

Manufactured No

100 Each

34.0000

2

100

D2282-7

Tube

**

SY 12.02.19
B78310 → 66x

Location

Loc Qty

Loc Code

WA021

34

67540

34

34x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

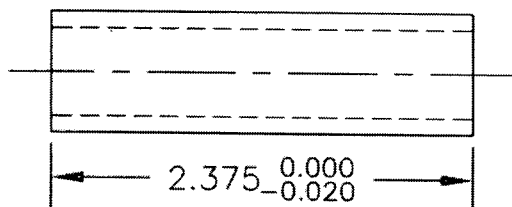
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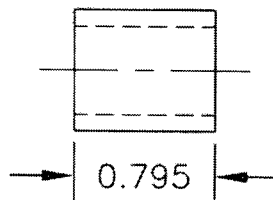


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

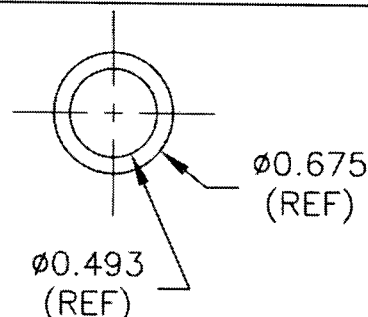
RELEASED
[Signature]
05/09/16



D2282-3

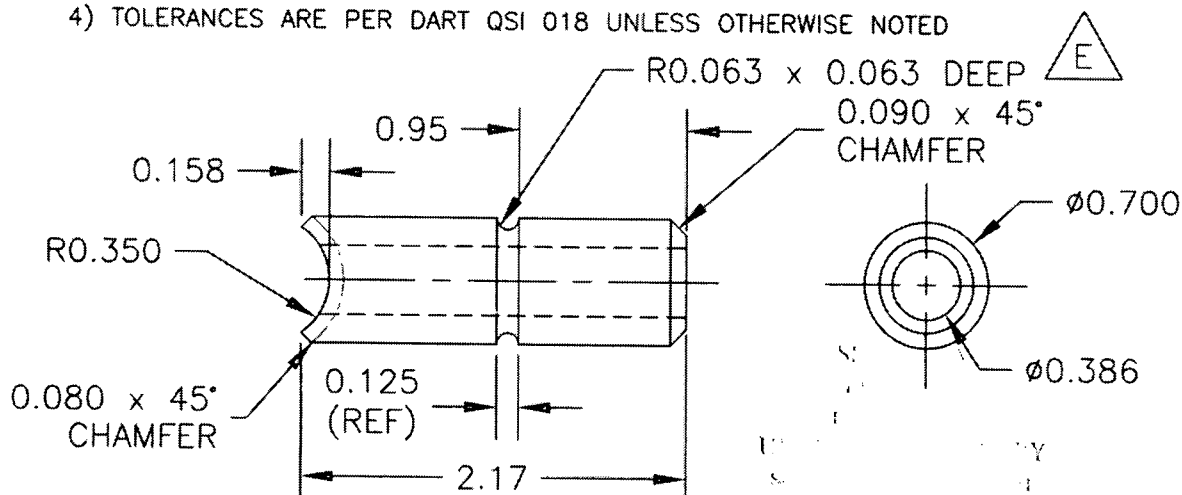


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

78-307 M-C-J
12/01/05

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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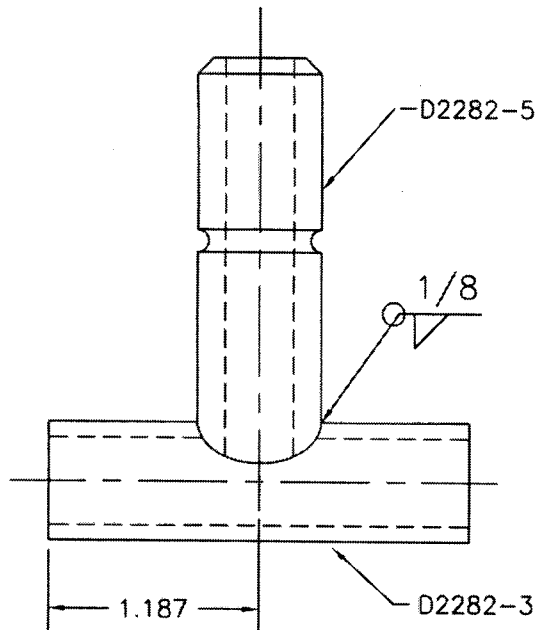
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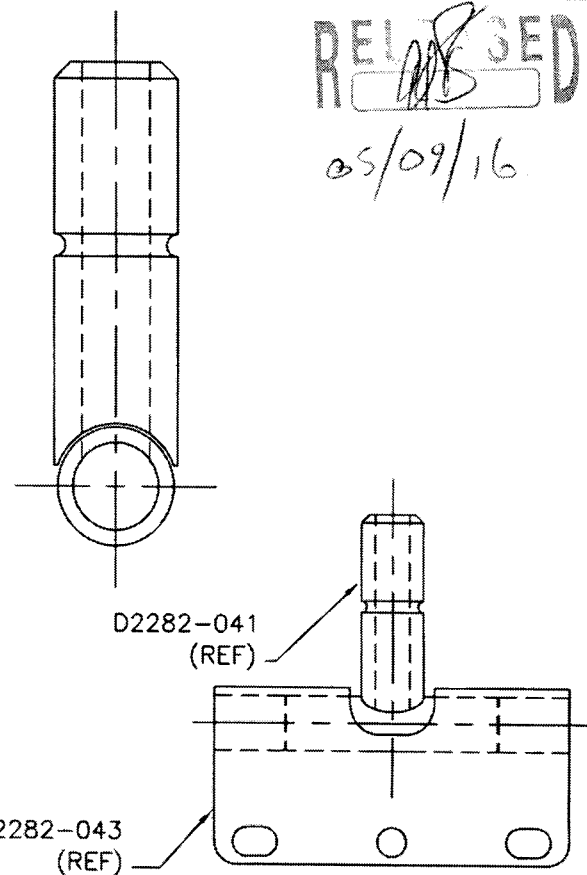


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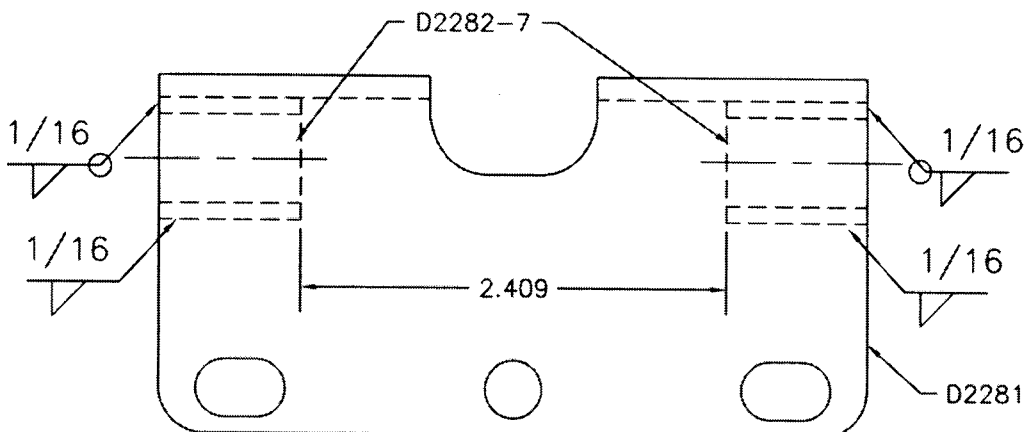
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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